

ABSTRACT

The invention is aimed at the provision of an automatic releasing-type rolling head for forming a tapered thread on a pipe in which the shock generated at the end of the thread rolling operation is alleviated and a thread automatic rolling roller retracting mechanism is not damaged. The rolling head includes shaft bearing plates 33 which are slidably supported in a plurality of guide grooves 36 radially provided on inner surfaces of the front and rear closures of the housing 30 and which are provided on their outer surfaces in the radial directions with oblique surfaces 33b, thread rolling rollers 35 rotatably supported by the shaft bearing plates 33, a cam ring 31 which rotates in the housing 30 and has cam oblique surfaces 31a opposed to the oblique surfaces 33b of the shaft bearing plates 33, a lever 44 which abuts at its oblique surface against a cam member 45 to prevent movement thereof in association with the cam ring 31 and an abutment member 41 which is pressed and moved by a thread-rolled pipe. When the to-be-rolled pipe is thread-rolled to a predetermined length, the oblique surface of the lever 44 moving in association with the movement of the abutment member 41 is gradually moved away from the cam member 45. The cam ring 31 is rotated and the shaft bearing plates 33 and the thread rolling rollers 35 are moved in radial and outward directions and released from the to-be-rolled pipe.